

DZOS-633-017

Work Order ID 54896



Page 1

January 5, 2010 8:38:21 AM

Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 05/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 05/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RI*Date: *10-1-05*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

10-01-12

2-Debur ends

3-Weld (TEND CAP, LUG PLATES & MOUNTING ANGLE) as per dwg

D2563 using DT 8343

A/R AL ROD Batch: *M111311**M111494*

4-Grind

10-01-12

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

BE 10/1/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54896

January 5, 2010 8:38:21 AM



Page 2

Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 05/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 05/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

2/8 10/01/18



QC

Memo

0.00

(x2)

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

10-01-18



HandFinish

Memo

0.00

2

Hand Finishing

140

QC3- Inspect Part Finish

0.00

m-l 10/01/19



QC

Memo

0.00

(2x)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54896

January 5, 2010 8:38:21 AM



Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 01/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 01/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Inspect for foreign object per QSI 024

2-Weld Remainig End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M111311

3-Grind

Ph 10.01.20

160



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

AD 0.01.20

170



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

=> 8.10.120



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54896

January 5, 2010 8:38:21 AM

Page 4

Item ID: D2563

Accept

Setup Start

Revision ID:

Stop

Item Name: Step Weldment Assembly

Start Date: 05/01/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 3/01/2010 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

✓ Touch up Alodine then

✓ Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M113170

START TIME:

2:30pm

OVEN TEMPERATURE:

370°F

FINISH TIME:

3:00pm

⇒ 10-01-21

(X2) Ø

190

Wing Walk as per dwg QSI005 4.4 Batch 112900

0.00



HandFinish

Hand Finishing

Memo

0.00

BR 10-01-25.

②.

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/04/26 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54896

Page 5

January 5, 2010 8:38:21 AM

Item ID: D2563

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 05/01/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PP 54893

0.00

Packaging

PC 10/01/26 (2)

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27 J

MF

10-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 8:38:25 AM

Page 1

Work Order ID: 54896

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2244-116 Step Extrusion		Manufactured	No			100	Each	33.0000	2.0000		10.01.20	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

33

38023

33

100

Each

33.0000

4.0000

2

10.01.20

D2561

Manufactured

No

Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

33

53616

33

100

Each

23.0000

4.0000

4

10.01.20

D2564

Manufactured

No

Mounting Angle

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

47966

23

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

January 5, 2010 8:38:25 AM

Work Order ID: 54896



Parent Item: D2563



Parent Item Name: Step Weldment Assembly

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2673-34 End Plate		Manufactured	No			100	Each	31.0000	4.0000			

10.01.20

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	31	
<u>54361</u>	31	

2+2

January 5, 2010 8:38:25 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

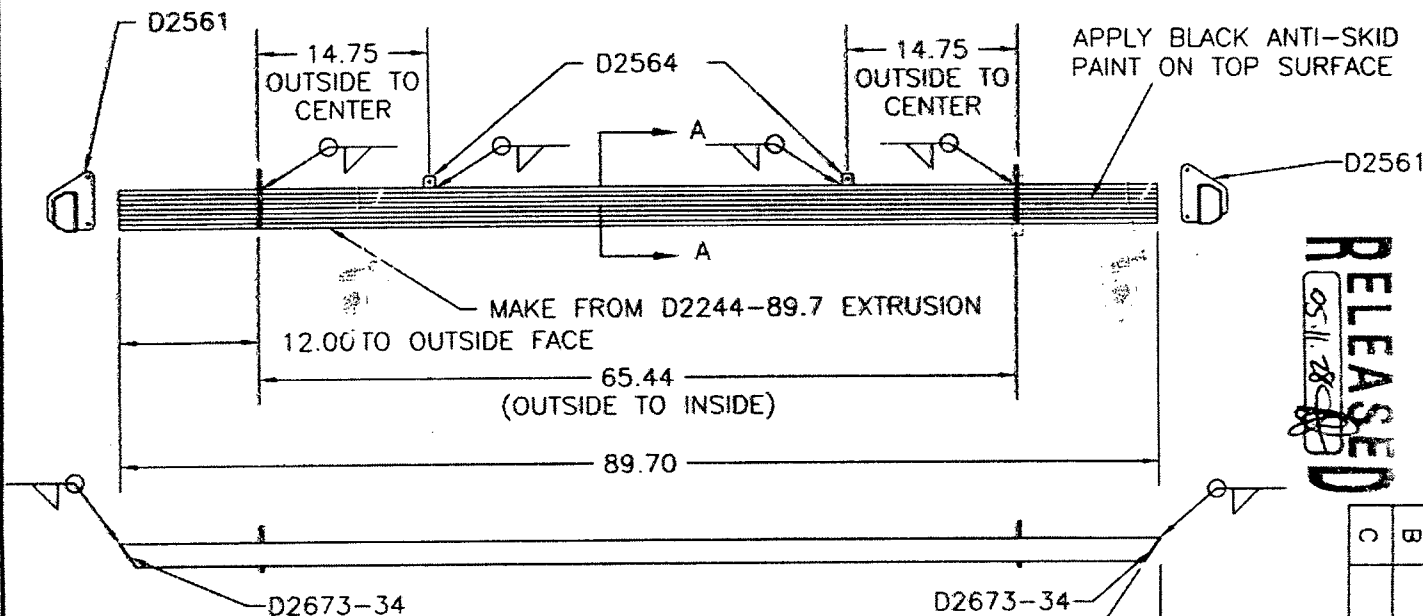
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

D2563

54524
10-1-05

RELEASED
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	44	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
44	44	D2563
DATE	TITLE	REV. C
05.11.14	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
A	96.04.26	NEW ISSUE
B	97.05.14	END CAPS CHANGED (WAS D2248)
C	05.11.14	UPDATE NOTES
		SCALE 1:1.5



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries